

Work Order ID 78943

78943

Page 1

January-17-12 1:30:08 PM

Item ID: D3140-08

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Door

Stop *NS2*

Start Date: 17/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.C.J

Date: 12/01/17

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3140

Rev F

100

0.00

100

Packaging

Memo

0.00

Packaging

Pick kit to ship to Delastek

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

12/07/21 JB

12.02.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78943

78943

Page 2

January-17-12 1:30:08 PM

Item ID: D3140-08 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door
 Start Date: 17/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>16439</u>								
	Purchase Part Number: D3140-08								
	Supplier: Delastek								
	Ship kit and make as per dwg								
	Conformity Certificate and Process sheet required								
130	Receive & Inspect for Damage & Mat'l Certs	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC6- Inspect dimensions to drawing	0.00							
140									
QC	Memo	0.00							
Quality Control	Ensure a copy of certification of conformity and process sheet from Delastek is attached.								

CY 12/02/17 (1)

16439/17 (1)

(1) 13.12.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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January-17-12 1:30:08 PM

Item ID: D3140-08 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Door
Start Date: 17/01/2012 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 31/01/2012 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

13-12-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-17-12 1:30:11 PM

Page 1

Work Order ID: 78943

78943

Parent Item: D3140-08

D3140-08

Parent Item Name: Door

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3140-10		Manufactured	No			100	Each	5.0000	1	1	✓		
D3140-10									**				
Doubler Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				st151				5					
					53768			5					
D3140-92		Manufactured	No			100	Each	11.0000	1	1	✓		
D3140-92									**				
Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				11					
					34374			1					
					50384			10					
D3140-99		Manufactured	No			100	Each	5.0000	1	1	✓		
D3140-99									**				
Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				5					
					36761			1					
					52632			4					
D3140-101		Manufactured	No			100	Each	1.0000	2	2	✓		
D3140-101									**				
Doubler													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA				1					
					50296			1					

20

53768

23

50384

20

52632

78724 JB 12/09/21

6/3/12 ①

D 3140-08P

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 78943

78943

Parent Item: D3140-08

D3140-08

Parent Item Name: Door

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3140-104

Manufactured No

100 Each

3.0000

1 1 ✓

D3140-104

Doubler

**

JB

Location

Loc Qty

Loc Code

CA

3

34378

3

34378

D3140-106

Manufactured No

100 Each

3.0000

1 1 ✓

D3140-106

Doubler

**

JB

Location

Loc Qty

Loc Code

CA

3

34380

3

34380

D3140-303

Manufactured No

100 Each

0.0000

1 1 ✓

D3140-303

Doubler

**

84215 *JB*

12/09/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A COMMENT
WITH APPROVAL

78943 M.C.J
12/01/17

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED Jh	APPROVED #	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1



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[illegible]

RELEASED

06.11.13

TAPER A/R AS SHOWN
PER TOOL # B30-23000-57T
(2 PLACES)

1.00 REF

1.00 REF

D3140-63 (REF)

D3140-61 (REF)

D3140-63 (REF)

FILL IN GAPS
5 BOND PADS
MA560 FOAM
(A/R)

E761/7781
2 PLY
THRU OUT INNER SHELL

R0.50

D3140-57 (3 PLACES)

D3140-59 (REF)

SECTION B-B

E761/7781
5 PLY
THRU OUT OUTER SHELL

ALL OUTER RADI
PER TOOL # B30-23000-01T/-02T

D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

Three triangles are shown, labeled 1, 2, and 3 from left to right. Each triangle is an isosceles triangle with its base horizontal. The numbers 1, 2, and 3 are centered inside each triangle.

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DART AEROSPACE LTD.

DESIGN

DRAWN BY	CB
----------	----

PART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

CHECKING

APPROVED	
----------	--

	DRAWING NO.
--	-------------

REV. F

DATE
06.10.06

TITLE
DOOR

SCALE

NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

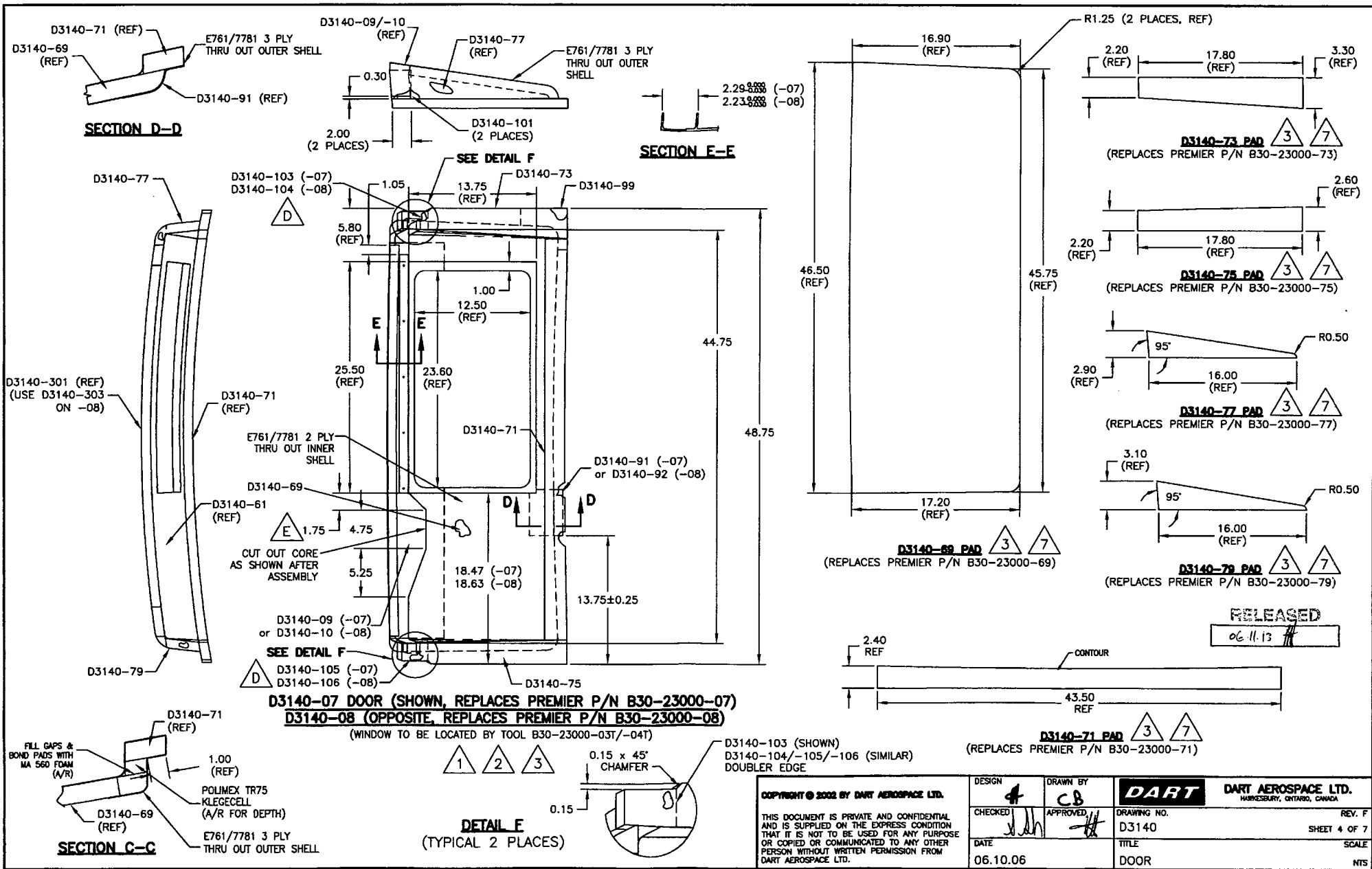
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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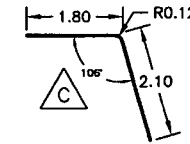
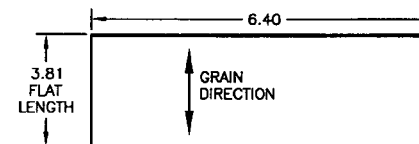
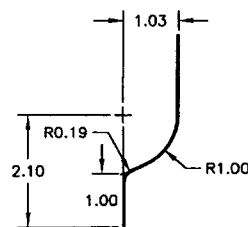
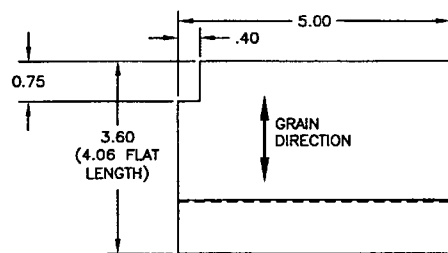
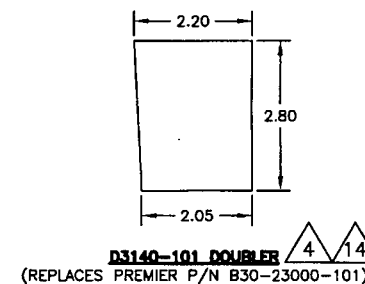
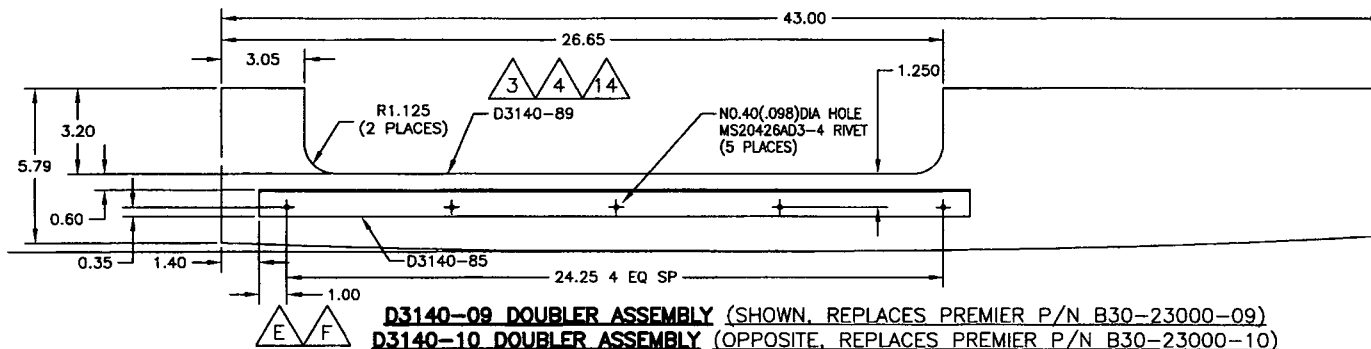
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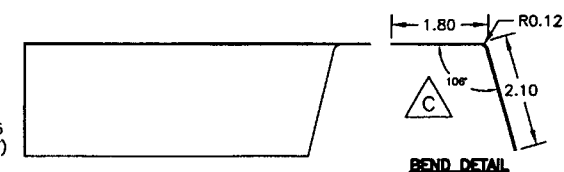
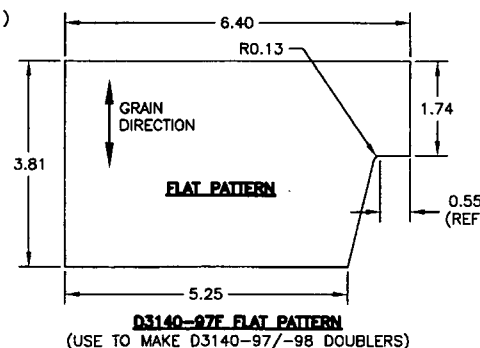
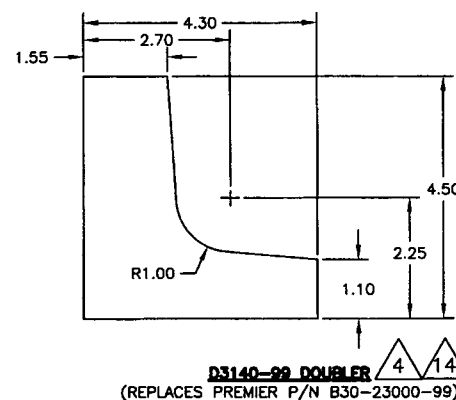
NOTE: Date & initial all entries

78943



D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)

D3140-92 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



D3140-97 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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DESIGN #	DRAWN BY CB	DART	DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA
CHECKED JUN	APPROVED JUN	DRAWING NO. D3140	REV. F SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

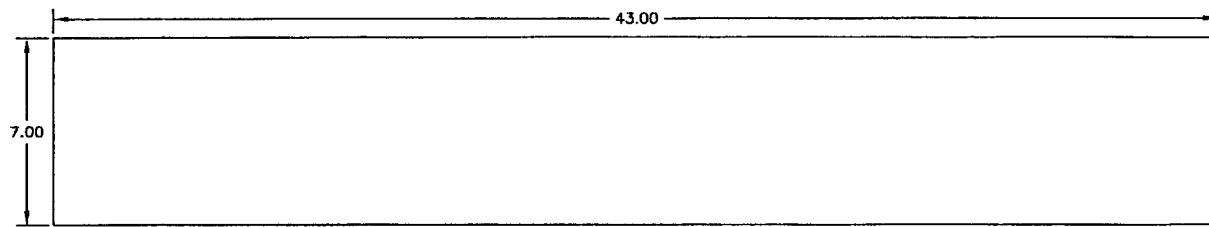
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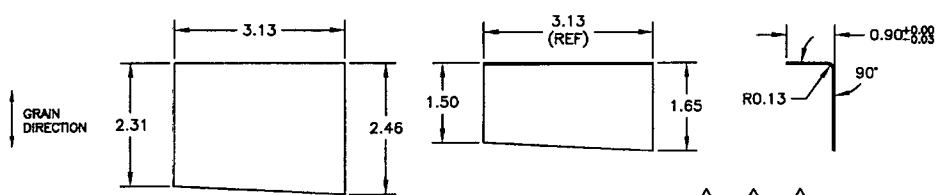
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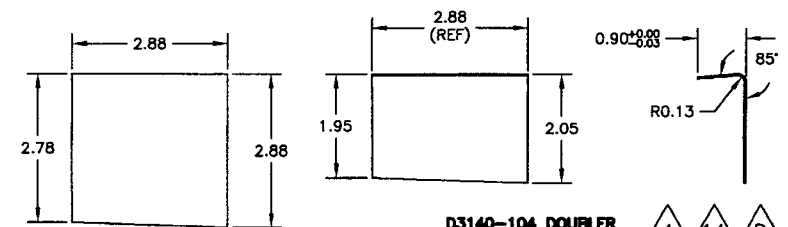


D3140-87 DOUBLER
(REPLACES PREMIER P/N B30-23000-87)



D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

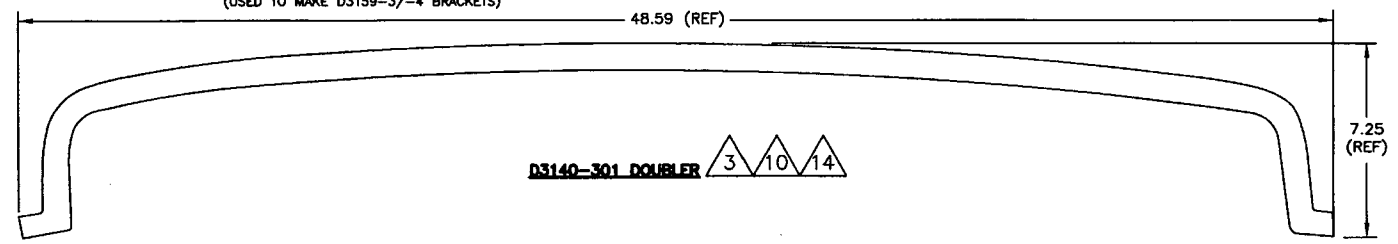
D3140-105 DOUBLER
(REF)
D3140-106 OPPOSITE



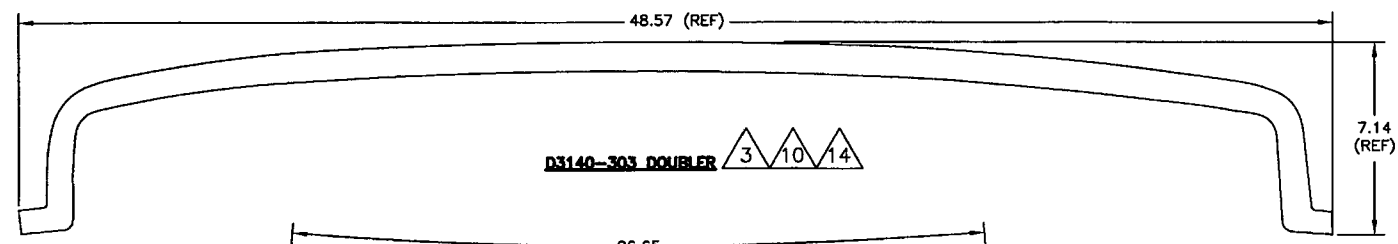
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

D3140-104 DOUBLER
D3140-103 OPPOSITE

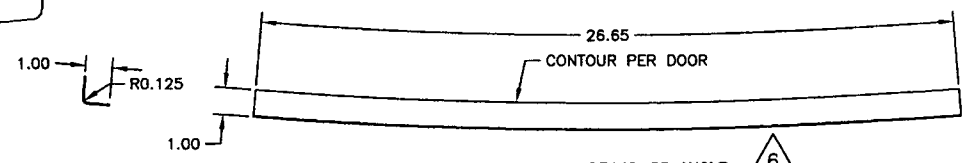
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

RELEASED
2.11.13

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		DATE 06.10.06	TITLE DOOR	DRAWING NO. D3140	SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

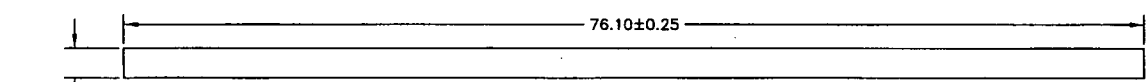
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

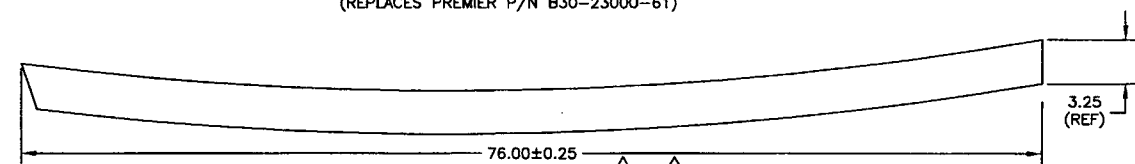
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

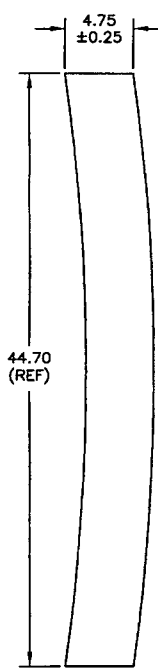
78943



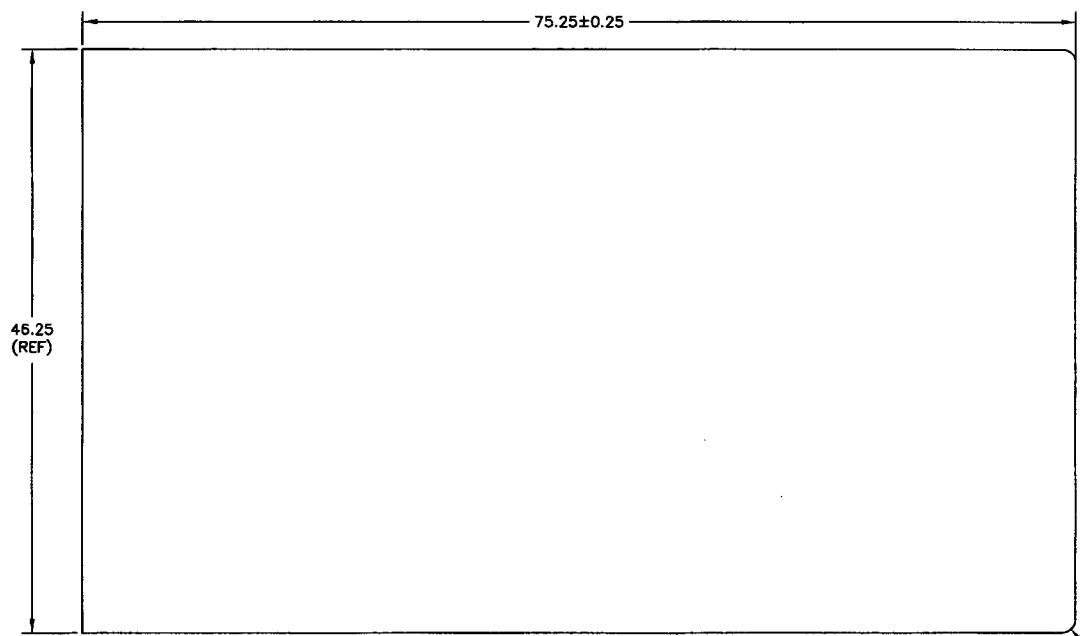
D3140-61 PAD $\triangle 3 \triangle 7$
(REPLACES PREMIER P/N B30-23000-61)



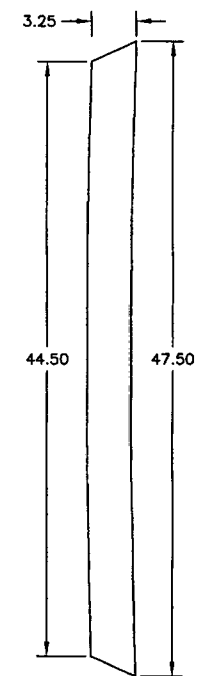
D3140-63 PAD $\triangle 3 \triangle 7$
(REPLACES PREMIER P/N B30-23000-63)



D3140-57 PAD
(REPLACES PREMIER P/N B30-23000-57)
 $\triangle 3 \triangle 7$



D3140-59 PAD $\triangle 7$
(REPLACES PREMIER P/N B30-23000-59)



D3140-241 DOUBLER $\triangle 5 \triangle 14$
(REPLACES PREMIER P/N B30-23000-241)

R1.00
(2 PLACES, REF)

RELEASED
06.11.13

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	CHECKED	APPROVED			DRAWING NO.
	DATE			D3140	SHEET 7 OF 7
	06.10.06			TITLE DOOR	SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DELASTEK Inc.
2699 5e Avenue
Local 14, C.P. 10100
Grand-Mère, Québec G9T 5K7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	47937
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle



Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
03-05-2013	16-03-2012	20221	Chantal Lavoie	PO16439	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
Day & Ross Collect		Point de départ		Mathieu Doucet, ext.690	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC135-0019	Line #2 D3140-06 Door Right Non Assy (Grosse) U of M: Chaque B78941 DWG D3140 REV. F Serial # Lot # 40734. 40734	
1	0	1	DKC135-0020	Line #4 D3140-08 Door Right Non Assy (Petite) U of M: Chaque B78943 DWG D3140 REV. F Serial # Lot # 40734. 40734	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Feuille de Procédé

Client : DART US DART AEROSPACE LTD

Numéro Job : 40734

Numéro Soumission : 3407

Numéro B.A. :

Cette fois : 2012-04-26 No. B.V. :

Prsht Rev. : NC

Prem. fois : - - - Type :

Job précédente : 40172

Écrit par

Vérifié & Approuvé par

Commentaires

N° de pièce Client: D3140-06/08

Nom Dessin : DOOR KIT

Numéro Article : DKC135-0019/0020

Numéro Dessin : D3140

Projet Numéro : DK-359

Révision dessin : F

Matériel : Fibercote E-761

Date Dûe : 2012-07-02

Qté: 1 Udm: UNITE

Process Sheet Rév.: 05 remplacer AAC0559 et AAC0563 par
AAC2032 et AAC1361 respectivement, changé AC0883 et AC0884
par AAC1885 et AAC1887 respectivement à 2 endroits qui avait
étés oubliés

RNC7271

Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description :

1.0 AAC0854 Frekote #700-NC
Commentair Qty.: 0.030 UNITE(s)/Unit Total: 0.030 UNITE(s)
Frekote #700-NC N° de Lot: 1-33991-1

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs

Faire la préparation du moule selon IF135-0002 et IG-0009:

Date: 18-09-12 Sceau:



3.0 AMB0211 Epoxy prepreg E-761 style 7781

Commentair Qty.: 12.30 VERGE(s)/Unit Total: 12.30 VERGE(s)
Epoxy prepreg E-761 style 7781 N° de Lot: 1-35874-1

4.0 DECOUPE Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs














Découpe des tissus pré-impregné E-761 en paquet de 10.5 pi. (7 Paquet = 24.5 verges)

Quantité: 1 Date: 18-09-12 Sceau:














Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: DOOR KIT	
Numéro Job: 40734		Numéro Article: DKC135-0019/-0020	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
5.0	DRAPAGE	Drapage	
			
Commentaire Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs			
Faire le drapage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0002			
Quantité: 1 Date: 19-09-12 Sceau:  			
6.0	AAC1885	Tissu à délaminer Release ply B	
Commentaire Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)			
Tissu à délaminer Release ply B # de Lot: 2-32882-1			
7.0	AAC1887	Wrightlon 5200 Bleu P3	
Commentaire Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)			
Wrightlon 5200 Bleu P3 # de Lot: 1-33715-2			
8.0	AC0885	Feutre de drainage N° Airweave N 10	
Commentaire Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)			
9.0	AC0882	Sac à vide N° Stretchlon 700	
Commentaire Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)			
10.0	AC0886	Ruban à gommer jaune #: TIAT-200Y	
Commentaire Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)			
11.0	BAGGING	Faire le bagging sur la pièce	
			
Commentaire Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs			
Faire le bagging sur la pièce selon IF135-0002 et IG 0012.			
Quantité: 1 Date: 20-09-12 Sceau: 			
12.0	CUISSON	Cuisson de pièce	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs			
Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N° Cuisson: 7047			
Quantité: 1 Date: 20/09/12 Sceau: 			
13.0	DÉMOULAGE	Démoulage de la pièce	
			
Commentaire Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs			
Retirer le montage cuisson et faire les retouches de la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.			

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: DOOR KIT	
Numéro Job: 40734		Numéro Article: DKC135-0019/0020	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Quantité: <u>1</u>	Date: <u>24-09-12</u>	Sceau: 
14.0	INSPECTION	Inspection générale	
			
Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.			
	Quantité: <u>1</u>	Date: <u>21-12-12</u>	Sceau: 
15.0	AAC1618	Rohacell 71S 1"thick 49.2" x 98.4" plain	
Commentaire Qty.: 2.000 FEUILLE(s)/Unit Total : 2.000 FEUILLE(s)			
Rohacell 71S 1"thick 49.2" x 98.4" plain N° de Lot: <u>1-37808-2</u>			
16.0	DECOUPE	Découpe manuelle des pièces	
			
Commentaire Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs			
Faire la découpe des pièces de mousses structurales (Rohacell) sur la scie à ruban selon IF135-0002.			
	Quantité: <u>1</u>	Date: <u>04/12/12</u>	Sceau: 
17.0	SÉCHAGE/ ANEAL	Séchage /Anealing	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire le séchage du Rohacell selon IF135-0002 et les informations du manufacturier. N°			
Cuisson: <u>72.18</u>			
	Quantité: <u>1</u>	Date: <u>29/11/12</u>	Sceau: 
18.0	AMB0442	Film adhesif de EA9696 36" large x 0.06 (psf)	
Commentaire Qty.: 6.12 VERGE CAR(s)/Unit Total : 6.12 VERGE CAR(s)			
Film adhesif de EA9696 36" large x 0.06 (psf) N° de Lot: <u>2-35855-2</u>			
19.0	AAC2032	Core splice adhesive NB-51/301	
Commentaire Qty.: 5.0 PIED CARRE(s)/Unit Total : 5.0 PIED CARRE(s)			
Core splice adhesive NB-51/301 # de Lot: <u>1-36395-1</u>			
20.0	AAC1361	Putty AD Tech P-17	
Commentaire Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s)			
Putty AD Tech P-17 # de Lot: <u>1-38354-2</u>			

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

21.0 AAC1646 N° D3140-10, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-10, Doubler

N° de Lot:

1-37826-1

22.0 AAC1631 N° D3140-87, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-87, Doubler

N° de Lot:

1-37871-1

23.0 AAC1633 N° D3140-92, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-92, Doubler

N° de Lot:

1-37826-2

24.0 AAC1634 N° D3140-95, Doubler

Commentair Qty.: 3 UNITE(s)/Unit Total: 3 UNITE(s)

N° D3140-95, Doubler

N° de Lot:

1-37826-19

25.0 AAC1636 N° D3140-98, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-98, Doubler

N° de Lot:

1-37826-20

26.0 AAC1637 N° D3140-99, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-99, Doubler

N° de Lot:

1-37826-3

27.0 AAC1638 N° D3140-101, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)

N° D3140-101, Doubler

N° de Lot:

1-37826-4

28.0 AAC1640 N° D3140-104, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-104, Doubler

N° de Lot:

1-37826-5

29.0 AAC1642 N° D3140-106, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-106, Doubler

N° de Lot:

1-37826-6

30.0 AAC1643 N° D3140-241, Doubler

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-241, Doubler

N° de Lot:

1-37826-10

31.0 AAC1645 N° D3140-303, Doubler

Commentair Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)

N° D3140-303, Doubler

N° de Lot:

1-37826-7 et 1-37826-22

32.0 NETTOYAGE Nettoyage des pièces



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le nettoyage des doubliers selon IG 0063.

Quantité: 1 Date: 23-1-2013

Sceau:



Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 40734

Numéro Article: DKC135-0019/0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

33.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mise en place des doublers et des pièces de la mousse structurale selon IF135-0002.

Quantité: 1

Date: 24-1-2013

Sceau:



34.0

AAC1885

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

35.0

AAC1887

Wrighton 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

36.0

AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

37.0

AC0882

Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

38.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

39.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0002 et IG 0012.

Quantité: 1

Date: 24-01-2013

Sceau:



40.0

CUISSON

Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #21. N° Cuisson: 7036

Quantité: 1

Date: 25/01/13

Sceau:

4254 m L

41.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson de sur la pièce et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium. Garder seulement la barre qui sépare les deux pièces.

Quantité: 1

Date: 28/01/13

Sceau:



Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Cient: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

42.0

DECOUPE

Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Usinage des mousses structurales selon IF135-0002 et installer les doublers

Quantité: 1

Date: 7/02/13

Sceau:



43.0

INSPECTION

Inspection générale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.

Quantité: 1

Date: 7/02/13

Sceau:



44.0

AMB0211

Epoxy prepreg E-761 style 7781

Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)

Epoxy prepreg E-761 style 7781

N° de Lot: 36396-1

45.0

DRAPAGE

Drapage



Commentair Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs

Drapage de la coquille intérieure selon IF135-0002

Quantité: 1

Date: 22-02-13

Sceau:



46.0

AAC1885

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

47.0

AAC1887

Wrighton 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

48.0

AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

49.0

AC0882

Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

50.0


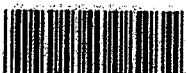


















AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: DOOR KIT	
Numéro Job: 40734		Numéro Article: DKC135-0019/-0020	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
51.0	BAGGING	Faire le bagging sur la pièce	
			
Commentaire Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs			
Faire le montage cuisson selon IF135-0002 et IG 0012.			
Quantité: 1 Date: 23-02-13 Sceau:   			
52.0	CUISSON	Cuisson de pièce	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs			
Faire la cuisson de la pièce selon IF135-0002, IG 0012 et PTN #20. N° Cuisson: 7412			
Quantité: 1 Date: 23/02/12 Sceau: 254			
53.0	DÉMOULAGE	Démoulage de la pièce	
			
Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs			
Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissus à délaminer.			
Retirer la pièce du moule.			
Quantité: 1 Date: 27-2-2013 Sceau:  			
54.0	INSPECTION	Inspection générale	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnelle".			
Quantité: Date: Sceau: Non fait par QA  16avril/2013 IV			
55.0	TRIMAGE	Trimage	
			
Commentaire Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs			
Faire le trimage de finition de la pièce selon IF135-0003.			
Quantité: 1 Date: 27-2-2013 Sceau:   12-04-2013  4435			

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40734

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

56.0 AAC1021 Dupont Primer N° 7704S
Commentaire Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-36433-1

2 partie
Lot: 1-37302-1

57.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase
Commentaire Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-38821-1

2 partie
Lot: 1-38821-1

58.0 PRIMER Application primer



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

première partie 01-03-13

Faire l'application du primer selon IG 0008.

Quantité: 1 Date: 16-04-13 Sceau: 43790 N° fiche Mélange: N/A

59.0 SABLAGE Sablage



Commentaire Setup: 0.00Hrs/ Run: 240.0000Min Total Run: 4.0000Hrs

Faire le sablage du primer selon IF135-0003.

Quantité: 1 Date: 05/03/13 Sceau: 7

18/04/13 4433 MM

60.0 PRIMER Application primer



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run: 1.0000Hrs

première partie 05-03-13

Faire l'application du primer selon IG 0008.

2 partie
Quantité: 1 Date: 18-04-13 Sceau: 57 N° fiche Mélange: N/A

61.0 IDENTIFICATION Identification des pièces



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanismes de porte selon IG 0055.

N° de pièce Grosse porte: D3140-06

N° de pièce Petite porte: D3140-08

N° de Job (sur les 2 pièces): 40734
Date de fabrication (sur les 2 pièces): 06/03/2013 19/04/2013

Sceau d'inspection: 19/04/2013

Quantité: 1 Date: 06/03/2013 Sceau: 57

Date: Jeudi, 2012-04-26 14:13:59
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 40734

Numéro Article: DKC135-0019/-0020

Numéro Job:



Séq.:

Machine ou Opération:

Description :

62.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.

Quantité: 1 kit Date: 23 avr. 13 Sceau:

63.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Emballer et entreposer selon IG 0057.

Quantité: 1 kit Date: 3/5/13 Sceau:

IDENTIFICATION DE LA PIÈCE

Fournisseur	Client	Numéro dessin	Rev	Numéro de Pièces
Delastek Aéronautique	Dart Aerospace Ltd.	D3140-06/08	F	DK DK-359- - -
No. de commande	Nom du produit	No Travail	No Série	Article
N/A	DOOR KIT	40734	N/A	DKC135-0019/002
Garantie (Oui/Non)	NON			Client
				D3140-06/08
				Quantité
				1

DESCRIPTION DE LA NON-CONFORMITÉ

Cause	Mauvaise adhérence	Responsabilité	Composite
Situation requise	Situation actuelle		
Aucune bulles entre les tissus	Suite a l'inspection de tap test, il y a des bulles d'air qui ont été emprisonné entre les tissus.		

Impact réels et potentiels	(Oui/Non)	Coût associé	0
Effets sur produits en inventaire	NON	Si ou détailler les effets: N/A	Disposition des produits affectés N/A
Effets sur produits en cours	NON		
Effets sur produits livrés	NON		
Autres effets réels ou potentiel	NON		

DISPOSITION DU PRODUIT NON-CONFORME

Accepté tel quel	Retouche	Dérogation	X	Réparation	Rebut	Autres
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DÉTAIL SUR LA DISPOSITION

Persez un trou de 1/8" aux endroits en fautes.

DISPOSITION	COMPLÉTÉ PAR	DATE	TEMPS	TAUX

No Travail de réparation :

N/A

Conformité après correction

OUI ☐

NON ☒

Disposition finale:

N/A

ACTION PREVENTIVE/CORRECTIVE REQUISE

NON ☒

OUI ☐

Numéro : N/A

COMPLÉTÉ PAR LE SERVICE APRES VENTE (SI REQUIS)

BON LIVRAISON	N/A	BV VAM	N/A
No RMA	N/A	RNC Client	N/A
DATE RECEPTION	N/A	WATBILL	N/A
DATE EXPÉDITION	N/A	CERTIFICAT	N/A

COÛT DE LA NON-CONFORMITÉ

ADMINISTRATION	35.00 \$
MATIERE PREMIERE	- \$
EXPERTISE	- \$
MAIN D'ŒUVRE	- \$
TRANSPORT	- \$
AUTRE	- \$
TOTAL	35.00 \$

Devise

☐ USD

☒ CAD

AUTHENTIFICATION

COMPLÉTÉ PAR Isabelle Veillette

DATE 2013-02-28

SCEAU

INSPECTÉ PAR Isabelle Veillette

DATE 2013-02-28

SCEAU

APPROUVÉ PAR

DATE

SCEAU